

FIRE RED

Dart Aerospace Ltd.

Date: Tuesday, 31/03/2009 1:04:49 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PEDAL LOCK BASE  
 Job Number : 46747  
 Estimate Number : 10444  
 P.O. Number :  
 This Issue : 31/03/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D33681  
 First Issue : / / Type : MACHINED PARTS Drawing Number : D3368 REV B  
 Previous Run : 44255 Drawing Revision : B  
 Material :  
 Due Date : 07/04/2009 Qty: 8 Um: Each  
 Written By :  
 Checked & Approved By : JUD 09.03.31  
 Comment : Est. A 05.01.27 New issue KJ/JLM  
 Est Rev:B 08-07-17 add QC3 DD verified by:ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2000X02000 6061-T6 Bar 2.00 x 2.00



Comment: Qty.: 0.9277 f(s)/Unit Total : 7.4214 f(s)  
 6061-T6 Bar 2.0" x 2.0"  
 Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)  
 (M6061T6B2.000x02.000)  
 Batch: 110 936

88 09/04/01

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: Machine D3368-1 as per Folio FA499 and Dwg D3368  
 Identify as D3368-1  
 Deburr

J.F. / DHA 09/04/02

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. / DHA 09/04/02

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

H.A 09/04/02

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

CMD / Fd.

09/04/07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK BASE

Job Number: 46747

Part Number: D33681

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M102391



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME: 11:15 am

OVEN TEMPERATURE: 320°F

FINISH TIME: 11:45 am

9/4

09-04-16

(18)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(8)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-04-16

8.0

PACKAGING 1

PACKAGING RESOURCE #1



(82)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ~~Cat~~ 490

9/4/17

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/22 4/2

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C209104117

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 46747
Description: Pedal Lock Base		Part Number: D3368-1
Inspection Dwg: D3368	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

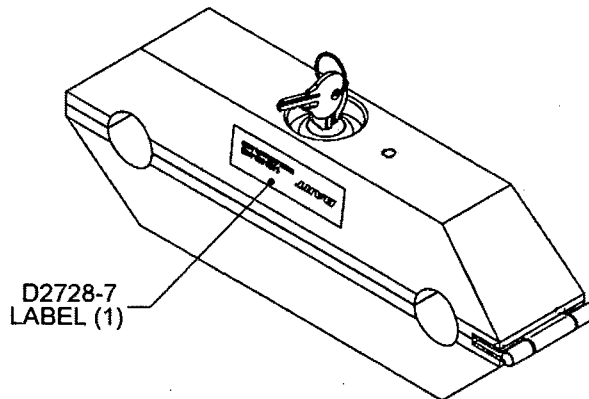
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.25	+/-0.030	10.25				
7.250	+/-0.010	7.256	✓			
0.107	+/-0.010	.107	✓			
1.800	+/-0.010	1.795	✓			
0.750	+/-0.010	.750	✓			
Ø1.031	+/-0.010	Ø1.031	✓			
45°	+/-0.5°	45°	✓			
0.250	+/-0.010	.250	✓			
2.00	+/-0.030	1.999	✓			
7°	+/-0.5°	7°	✓			
Ø0.230	+0.005/-0.000	Ø.230	✓			
1.250	+/-0.010	1.252	✓			
1.075	+/-0.010	1.076	✓			
R0.500	+/-0.010	R0.500	✓			
0.375	+/-0.010	.374	✓			
0.310	+/-0.010	.312	✓			
1.450	+/-0.005	1.450	✓			
0.375	+/-0.010	.375	✓			
5.125	+/-0.010	5.135	✓			
.650	±.010	.650	✓			
.485	±.010	.481	✓			

Measured by: J.F.	Audited by: M A	Prototype Approval:	N/A
Date: 09/04/01	Date: 09/04/02	Date:	N/A

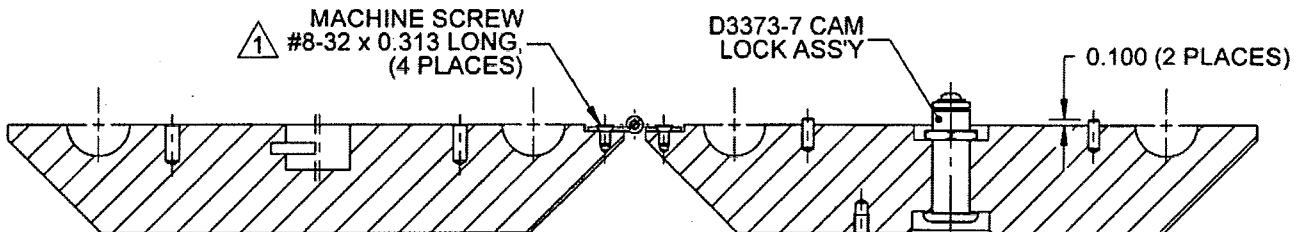
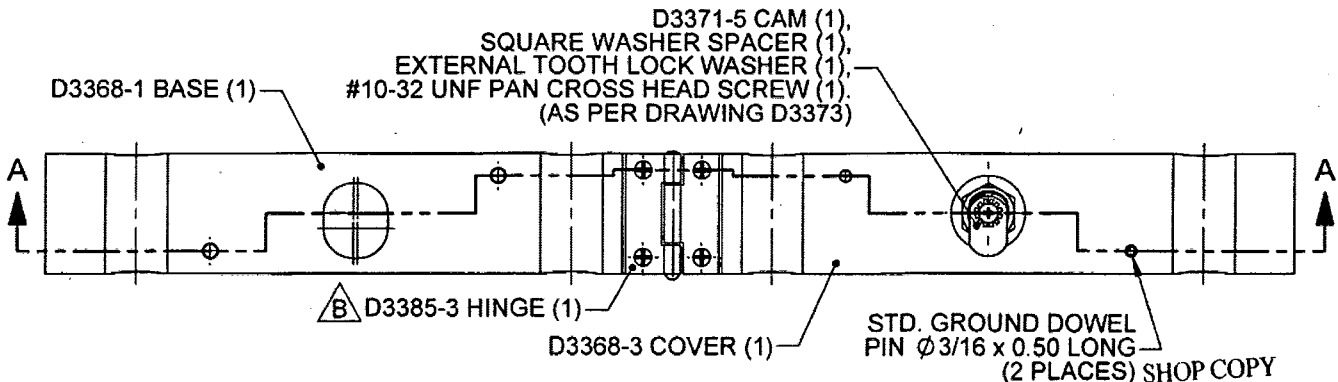
Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Dimensions and tolerances changed	KJ/JLM	
C	08.07.23	0.700 dimension removed	KJ/DD	

**DART**

DESIGN #3	DRAWN BY [Signature]	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. <b>D3368</b>	REV. B SHEET 1 OF 3
DATE <b>05.03.22</b>		TITLE <b>PEDAL LOCK</b>	SCALE 1:3
A	05.01.19	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

**RELEASED**

25/04/28

**PEDAL LOCK SHOWN LOCKED WITH KEY****SECTION A-A****D3368-051 PEDAL LOCK ASSEMBLY****NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAU P/N 385-044
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER

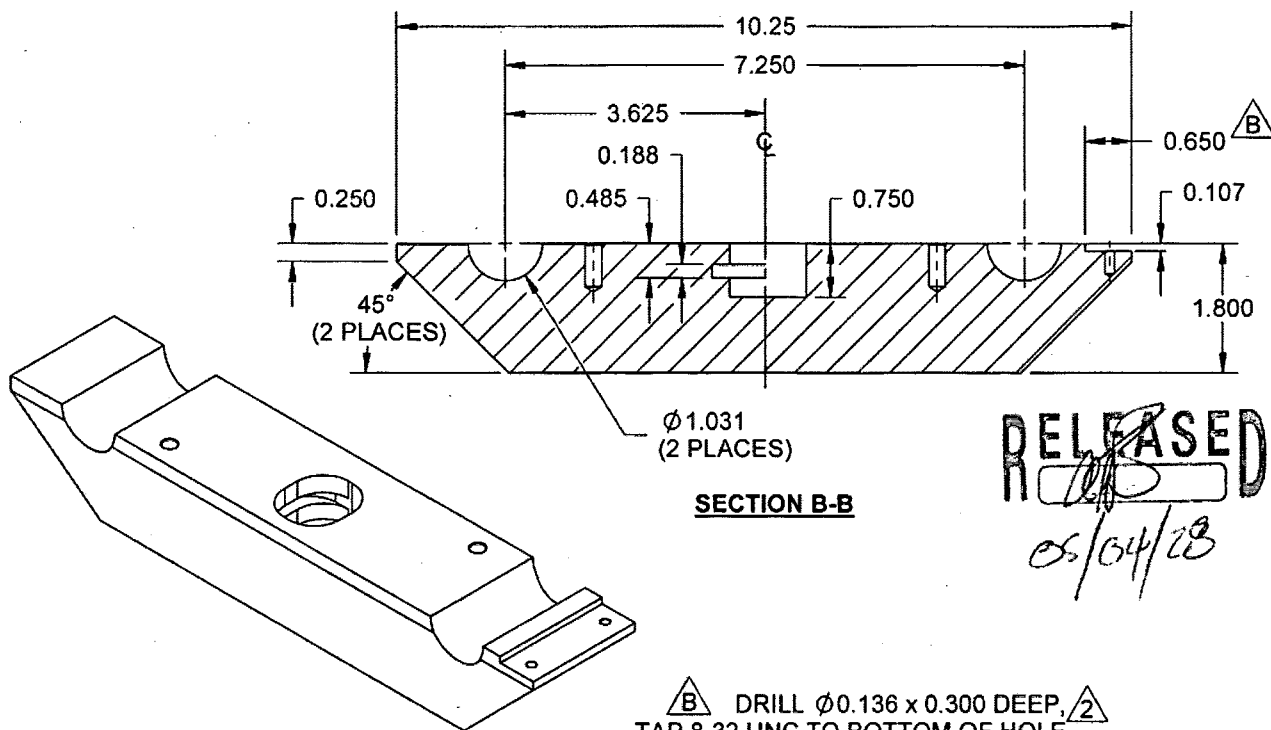
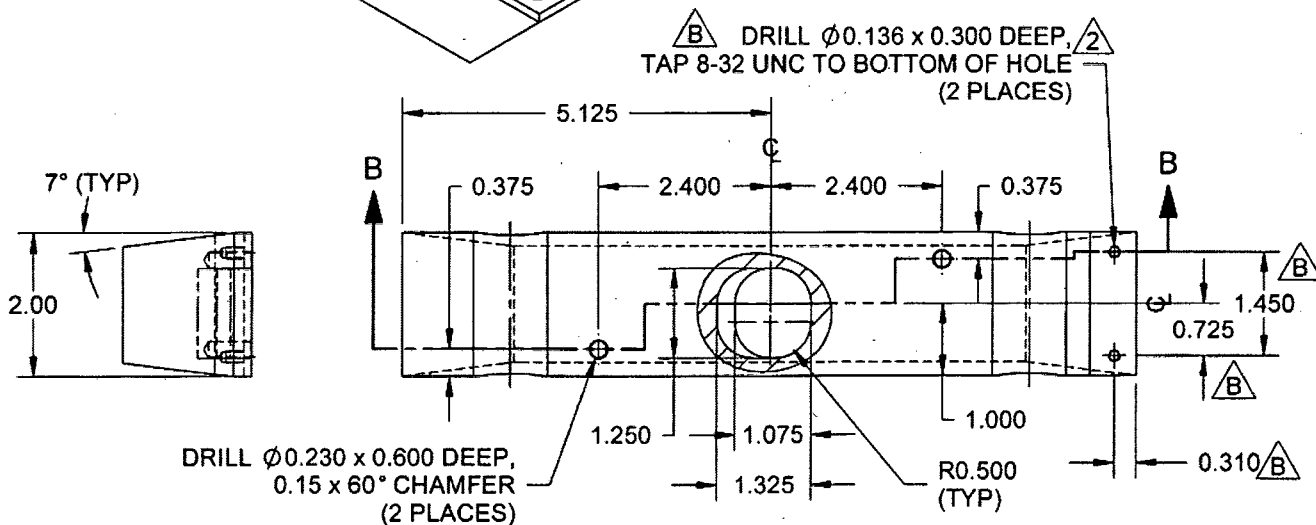
NO. 46777

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**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3368</b>	REV. B SHEET 2 OF 3
DATE <b>05.03.22</b>	TITLE <b>PEDAL LOCK</b>	SCALE 1:2.5	


**RELEASED**  
*[Signature]*  
05/04/23**D3368-1 BASE****NOTES:**

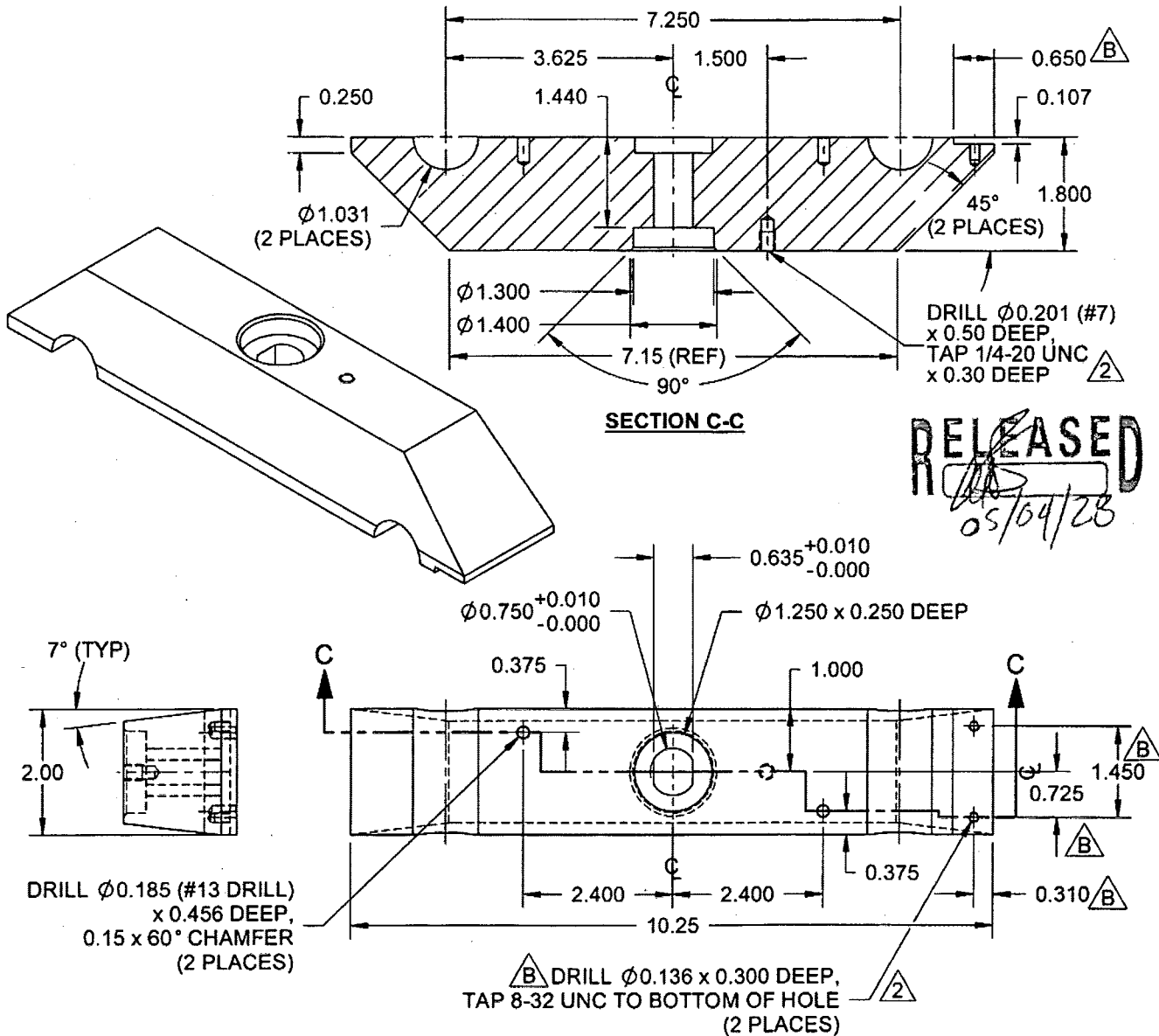
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DESIGN 13	DRAWN BY 13	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED 77	APPROVED 	DRAWING NO. <b>D3368</b>	REV. B SHEET 3 OF 3
DATE <b>05.03.22</b>		TITLE <b>PEDAL LOCK</b>	SCALE 1:2.5



**D3368-3 COVER**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) UNCLAS  
(REF. DART SPEC. M6061T6B) SUB  
2) COVER INSIDE HOLES PRIOR PAINTING  
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED NC  
5) ALL DIMENSIONS ARE IN INCHES  
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

4 3

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